

Work Order ID 66991

Thursday, March 03, 2011 10:03:32 AM



303
463
269 Page 1

Item ID:	D4323-15	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Spacer					
Start Date:	3/3/2011	Start Qty:	450.00		Cust Item ID:	
Required Date:	3/11/2011	Req'd Qty:	450.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-03-7	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4323	PAT P03 PAT								
100		0.00							
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: PAT P03 Prog Rev: PAT P03 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

B11-3-8

11/03/08 (769)

B11-3-8

~~PRELIMINARY ISSUE~~

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66991

Thursday, March 03, 2011 10:03:32 AM



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Item ID: D4323-15

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Spacer

Start Date: 3/3/2011 Start Qty: 450.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 450.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

- inspect to PA3

counted



QC

Memo

0.00

Day only

X765

Quality Control

QSP019

8/10/08

ENG

130

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

11/3/08

769

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/10

11.08.08

PRELIMINARY ISSUE

POSITIVE RECALL

EFFECTIVE 10/3/08

RELEASED 11/10/13

DATE 11/05/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, March 03, 2011 10:03:39 AM

Page 1

Work Order ID: 66991

Parent Item: D4323-15

Parent Item Name: Spacer



Start Date: 3/3/2011

Required Date: 3/11/2011

Start Qty: 450.00

Required Qty: 450.00

Comments: IPP Rev:A 11.02.14 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	1,019.537	0.007	3.315789		5.5	



6185 KYDEX .080"



B11-3-8

Location

therm

109703

116576

Loc Qty

1019.537564

81.189115

938.348449

Loc Code

116576

720
769

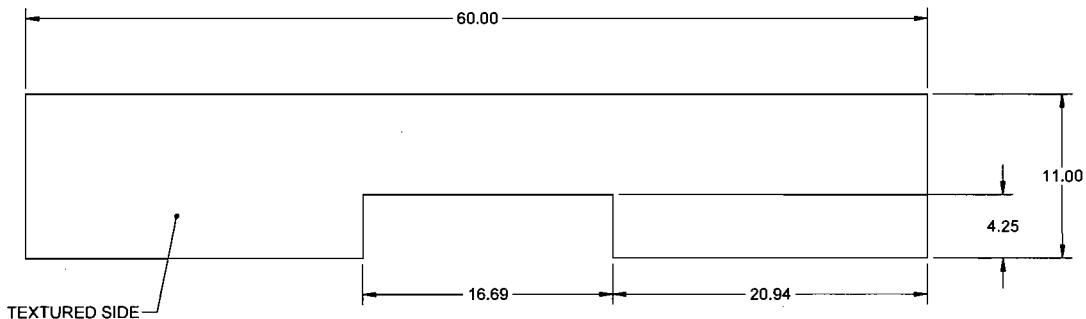
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

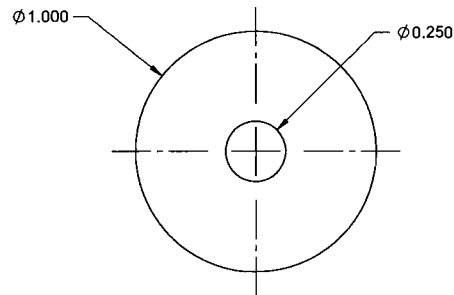
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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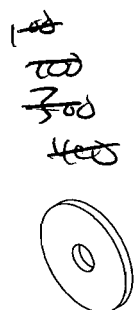
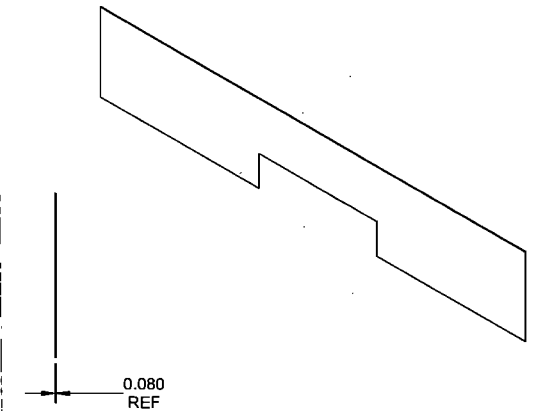
NOTE: Date & initial all entries



D4323-13 CEILING, CENTER FWD



D4323-15 SPACER



**PRELIMINARY
ISSUE**

- NOTES:
- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P1-HAIRCCELL, IVORY #62015
REF DART SPEC MKYD6185S.080-P1-62015
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
 - 7) WEIGHT: 1.70 lbs

DESIGN	<i>JS</i>	DART AEROSPACE LTD	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. PA3
MFG. APPR.		D4323	SHEET 8 OF 11
APPROVED		TITLE	SCALE
DE APPR.		PANEL	NTS
DATE	11.02.09	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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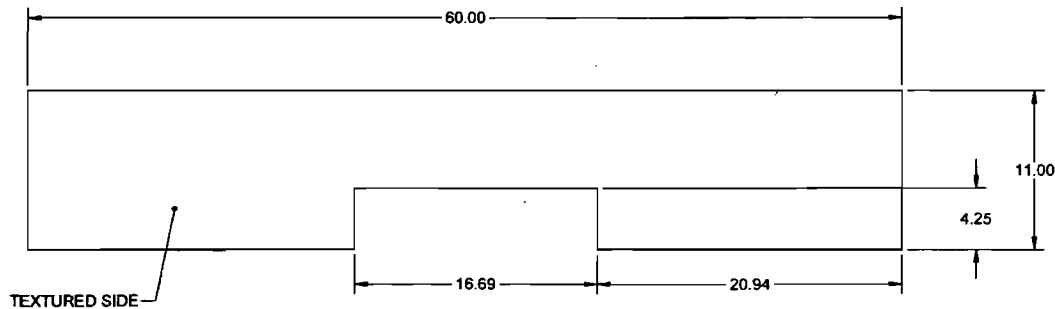
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

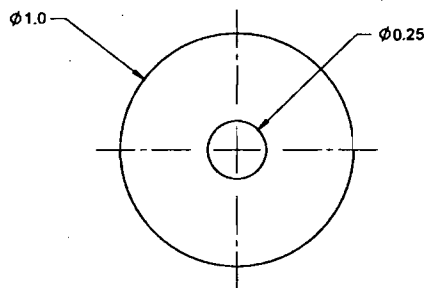
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries









D4323-13 CEILING, CENTER FWD



D4323-15 SPACER

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: -13 = 2.33 lbs
-15 = 0.003 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4323	SHEET 9 OF 15
APPROVED		TITLE	SCALE
DE APPR.		PANEL	NTS
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RELEASED
2011-05-10
WJD

66991

